

Work Order ID 58856

Wednesday, May 19, 2010 1:42:39 PM



Page 1

Item ID: D3942-1

Accept



Setup Start



Revision ID:

Item Name: Angle

Stop



Start Date: 5/19/2010 Start Qty: 50.00



Cust Item ID:

Required Date: 5/26/2010 Req'd Qty: 50.00



Customer:

Reference:Approvals: Process Plan: *R*Date: *10-5-19*

Tooling:

Date:

Run Start



QC: _____

Date: _____

SPC (Y/N):

Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
100	

100



Waterjet

FLOW CNC Waterjet

304.050

Memo

1-Cut as per Dwg D3942-1

Dwg Rev: *A*Prog Rev: *A*

2-Deburr if necessary

*10-5-20**65*

110



QC2- Inspect parts off machine FAI/FAIB

QC

Quality Control

Memo

0.00

0.00

10-5-20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Stop



Start Date: 5/19/2010 Start Qty: 50.00



Cust Item ID:

Required Date: 5/26/2010 Req'd Qty: 50.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

120



QC

Quality Control

Operation
Description

QC8- Inspect parts - second check

Set Up/
Run Hours

0.00

S 10/05/26

Draw
Number

Rev.

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130



Brake NC

Brake NC

Memo

1- Bend as per dwg D3942

0.00

S 10/05/26

0.00

65

140



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

S 10/05/27

0.00

work
x65

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Work Order ID 58856

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Item ID: D3942-1

Accept



Setup Start



Revision ID:

Item Name: Angle

Stop



Start Date: 5/19/2010 Start Qty: 50.00



Cust Item ID:

Required Date: 5/26/2010 Req'd Qty: 50.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

150



Packaging

Packaging

Operation
Description

Identify as per dwg & Stock Location:

Set Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

0.00

0.00

160



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

10-5-27

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NOTE: Date & initial all entries

Picklist Print

Wednesday, May 19, 2010 1:42:43 PM

Page 1

Work Order ID: 58856



Parent Item: D3942-1



Parent Item Name: Angle

Start Date: 5/19/2010

Required Date: 5/26/2010

Comments:

Start Qty: 50.00

Required Qty: 50.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Qty Issued	Date Issued	Status
M304S18GA		Purchased		No		100	sf	140.0179	0.015	1.		

304/316 .050 Sheet

Location	Loc Qty	Loc Code
MAT20	140.0179	
108156	1.7	
111743	10.1	
112885	32.2179	
113062	96	

1810-5-26

(65)

108156

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DART AEROSPACE LTD	Work Order:	5D85C
Description: Angle	Part Number:	D3942-1
Inspection Dwg: D3942	Rev: A	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Measured by:	<u>iB</u>	Audited by:	<u>S</u>	Prototype Approval:	N/A
Date:	10-5-26	Date:	10/05/26	Date:	N/A

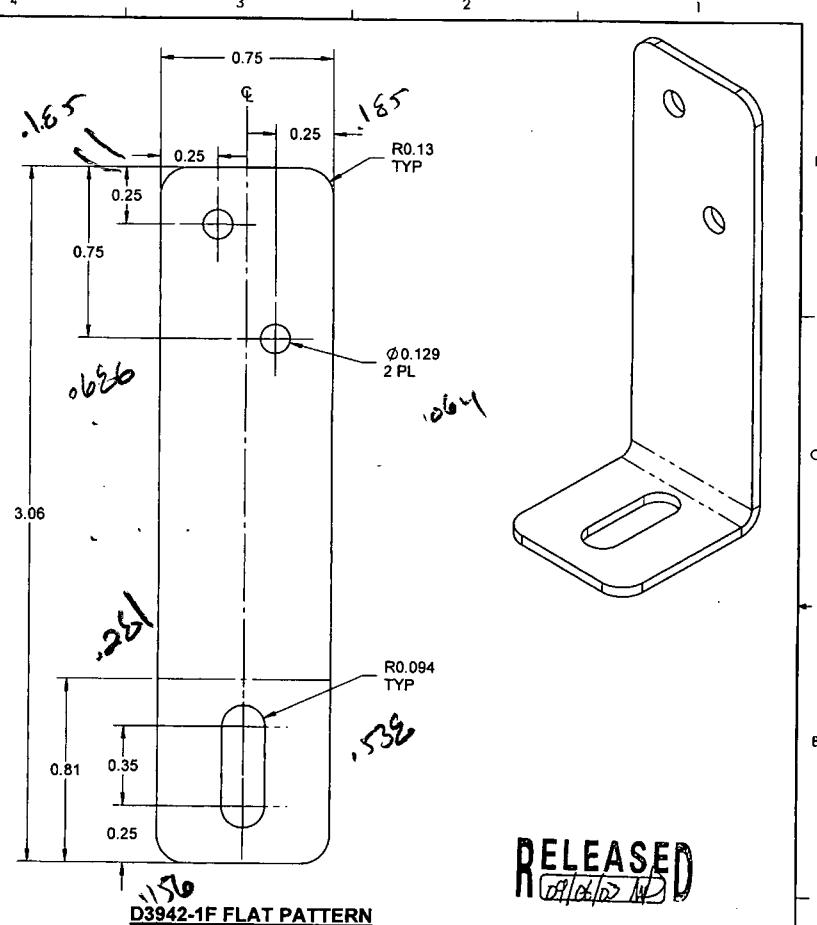
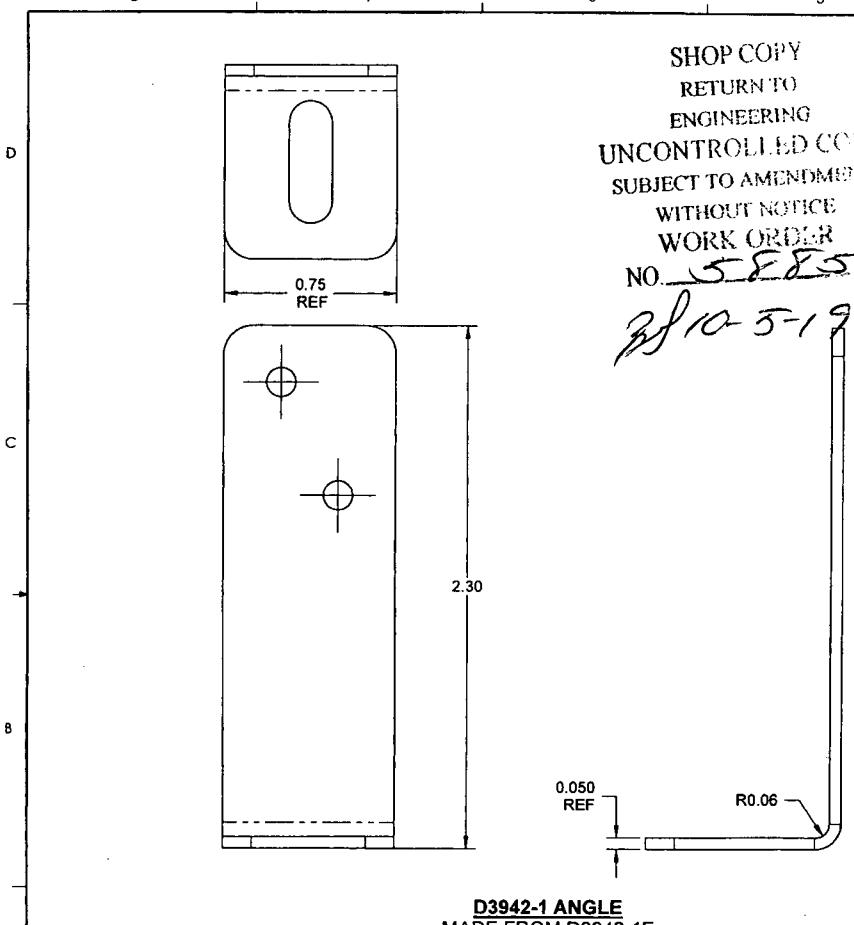
Rev	Date	Change	Revised by	Approved
A	09.06.22	New Issue	KJ	

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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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A NOTES:
 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET PER AMS 5513 OR AMS 5524
 18 GAUGE (0.050 THICK)
 REF DART SPEC M304S18GA
 2) FINISH: NONE
 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3942-1" AND B/N USING FINE POINT PERMANENT INK MARKER
 7) WEIGHT: 0.03 lbs

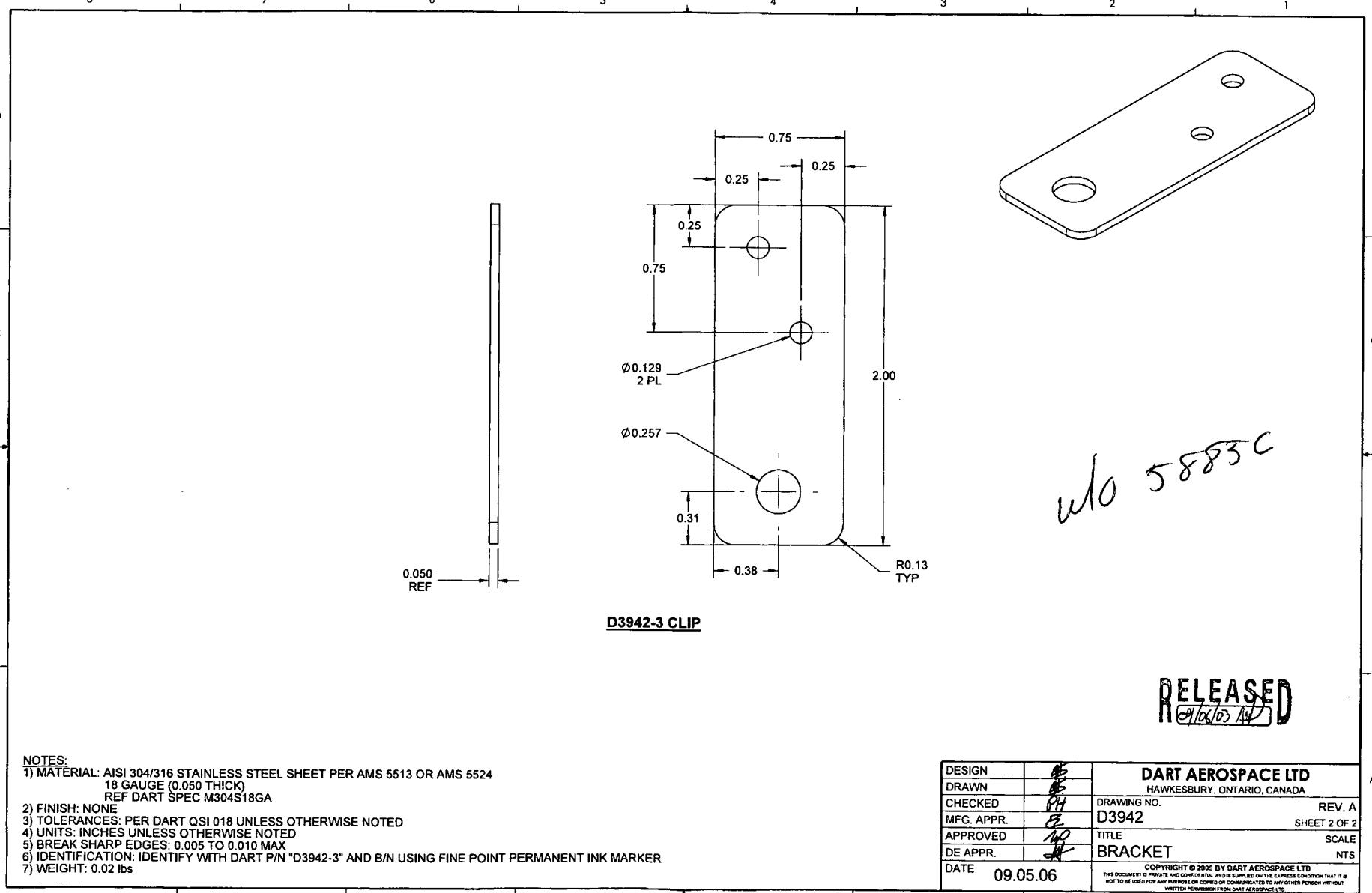
A	NEW ISSUE	09.05.06
REV.		BY DATE
DESIGN	<i>AS</i>	
DRAWN	<i>AB</i>	
CHECKED	<i>PH</i>	
MFG. APPR.	<i>CE</i>	
APPROVED	<i>MG</i>	
DE APPR.	<i>MG</i>	
DATE	09.05.06	
DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
DRAWING NO.	D3942	REV. A SHEET 1 OF 2
TITLE	BRACKET	SCALE NTS
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